



Identificatie van ISO-houders (Identification of ISO holders)

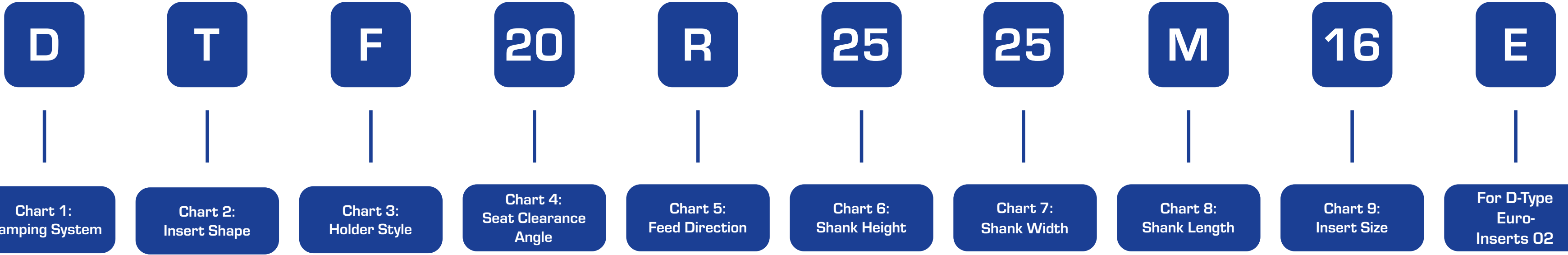


Chart 1: Clamping System

Clamping System					
Symbol	Clamp Types	Example of Structure	Symbol	Clamp Types	Example of Structure
C	Top Clamp		M	Top & Hole Clamp Type	
D	Double Clamp		P	Lever Lock Type (Insert is Supported by 1 face)	
E	Pin Lock Type (Insert is supported by 1 face)		S	Screw Clamp Type	

Chart 2: Insert Shape

Insert Shape					
Symbol	Insert Shape	Symbol	Insert Shape	Symbol	Insert Shape
A	Parallelogram 85°	M	Rhombic 86°		
B	Parallelogram 82°	O	Octagonal		
C	Diamond 80°	P	Pentagonal		
D	Diamond 55°	R	Round		
E	Diamond 75°	S	Square		
F	Diamond 50°	T	Triangular		
H	Hexagonal	V	Diamond 35°		
K	Parallelogram 55°	W	Trigon		
L	Rectangular				

Chart 3: Holder Style

Holder Style					
Symbol	Shape	Offset	Symbol	Shape	Offset
A		Nil	L		With Offset
B		Nil	N		Nil
D		Nil	R		With Offset
E		Nil	S		With Offset
F		With Offset	T		With Offset
G		With Offset	U		With Offset
J		With Offset	W		With Offset
K		With Offset	Y		With Offset

Chart 5: Feed Direction

Feed Direction					
Symbol	Right Hand Feed	Symbol	Neutral Feed	Symbol	Left Hand Feed
R		N		L	

Chart 4: Seat Clearance Angle

Seat Clearance Angle	
Symbol	Relief Angle
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
O	Special Angle

Chart 6: Shank Height

Shank Height	
Symbol	Height (mm)
12	12
16	16
20	20
25	25
32	32
40	40
50	50
00	Round shank.

Chart 7: Shank Width

Shank Width	
Symbol	Width (mm)
12	12
16	16
20	20
25	25
32	32
40	40
50	50
	Shank Diameter is Shown for Round Shank.

2 digits are used for each dimension in mm.

Chart 8: Shank Length

Shank Length	
symbol	Length (mm)
F	80
H	100
K	125
M	150
N	160
P	170
Q	180
S	250
T	300
U	350

For some Products, a Hyphen is used Instead of an Alphabet.

Chart 9: Insert Size

Cutting Edge			
symbol	Length (mm)	symbol	Length (mm)
Eg. for Triangle Inserts:		For Round Inserts:	
06	6.9	10	10
08	8.2	12	12
09	9.6	16	16
11	11.0	20	20
16	16.5	25	25
22	22.0	32	32
27	27.5		
33	33.0		

Cutting Edge Dimensions by Corner Radius : (This table shows X and Y dimensions based on O approach angle cutting edge inclinations)

Holders		Dimensions(mm)			Holders		Dimensions(mm)				
Symbol	Shapes	Corner Shapes	RE	X	Y	Symbol	Shapes	Corner Shapes	RE	X	Y
A			0.4	0.291	-	K			0.4	0.024	0.089
			0.8	0.581	-				0.8	0.048	0.178
			1.2	0.872	-				1.2	0.072	0.268
			1.6	1.162	-				1.6	0.096	0.357
			2.4	1.743	-				2.4	0.143	0.535
B			0.4	0.089	0.024	L			0.4	0.040	0.040
			0.8	0.178	0.048				0.8	0.079	0.079
			1.2	0.268	0.072				1.2	0.119	0.119
			1.6	0.357	0.096				1.6	0.159	0.159
			2.4	0.535	0.143				2.4	0.238	0.238
D			0.4	0.164	0.164	N			0.4	0.463	0.263
			0.8	0.329	0.329				0.8	0.925	0.471
			1.2	0.493	0.493				1.2	1.388	0.707
			1.6	0.658	0.658				1.6	1.850	0.943
			2.4	0.986	0.986				2.4	2.776	1.414
E			0.4	0.396	0.229	S			0.4	0.164	0.164
			0.8	0.793	0.458				0.8	0.329	0.329
			1.2	1.190	0.687				1.2	0.493	0.493
			1.6	1.587	0.916				1.6	0.658	0.658
			2.4	2.381	1.374				2.4	0.986	0.986
F			0.4	-	0.291	T			0.4	0.396	0.229
			0.8	-	0.581				0.8	0.793	0.458
			1.2	-	0.872				1.2	1.190	0.687
			1.6	-	1.162				1.6	1.587	0.916
			2.4	-	1.743				2.4	2.381	1.374
G			0.4	0.291	-	U			0.4	0.253	0.058
			0.8	0.581	-				0.8	0.506	0.116
			1.2	0.872	-				1.2	0.759	0.175
			1.6	1.162	-				1.6	1.013	0.233
			2.4	1.743	-				2.4	1.519	0.350
J			0.4	0.344	0.033	Y			0.4	0.002	0.033
			0.8	0.687	0.079				0.8	0.005	0.066
			1.2	1.031	0.118				1.2	0.008	0.099
			1.6	1.375	0.157				1.6	0.011	0.132
			2.4	2.062	0.236				2.4	0.017	0.198

Figures of „A“ and „RE“ to calculate Figure „B“

I.C. size (inch)	„øA“ dimensions (mm)	Nose symbol	Size (inch)	„RE“ dimension (mm)
-	5/32	02	[0]	0.203
-	6/32	04	1/64	0.397
-	7/32	08	2/64	0.794
2/8	8/32	12	3/64	1.191
-	[0]	16	4/64	1.588
3/8	-	24	6/64	2.389
4/8	-			
5/8	-			
6/8	-			
8/8	-			

Figures of „A“ and „RE“ to calculate Figure „B“

Insert Shape	Calculation
Triangle	$B = \frac{3}{2}A - RE$
Square	$B = (\sqrt{2}-1) \times (\frac{A}{2} - RE)$
Rhombic	$B = \left\{ \frac{1}{\sin(\frac{\theta}{2})} - 1 \right\} \times (\frac{A}{2} - RE)$

Calculation of the Nose Radius Dimensions (Unit in mm)

Insert Shape	Calculation
Triangle	$B = \frac{3}{2}A - RE$
Square	$B = (\sqrt{2}-1) \times (\frac{A}{2} - RE)$
Rhombic	$B = \left\{ \frac{1}{\sin(\frac{\theta}{2})} - 1 \right\} \times (\frac{A}{2} - RE)$